



Dart Aerospace Ltd.
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D3043-042

Job Sheet 181786



Part No: D3043-042

Job Qty: 2 ea

Part Name: Step Weldment RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/9/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev :A New Issue JLM 05-11-01

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		9/7/18	0.00	0.00	Start Up Large Fab-4		SL4
100	Large Fab	2 pcs		9/7/18	0.00	2.02	Large Fab 8		SL4 DAS 38
110	QC	2 pcs		9/7/18	0.00	0.00	QC6		38
120	Large Fab	2 pcs		9/7/18	0.00	2.02	Large Fab 8		SL4 3-89
130	QC	2 pcs		9/7/18	0.00	0.00	QC9		SL4
140	QC	2 pcs		9/7/18	0.00	0.00	QC5		CPC
150	HandFinish	2 pcs		9/7/18	0.00	0.37	HandFinish1		CPC
160	Large Fab	2 pcs		9/7/18	0.00	2.02	Large Fab 8		DR 18/09/26
170	QC	2 pcs		9/7/18	0.00	0.00	QC10		38 DAS
180	QC	2 pcs		9/7/18	0.00	0.00	QC5		9-89 38
190	HandFinish	2 pcs		9/7/18	0.00	0.37	HandFinish6		DR 18/10/11
210	Powdercoat	2 pcs		9/7/18	0.00	0.35	Powdercoat1		BE 18/10/103
220	HandFinish	2 pcs		9/7/18	0.00	0.37	HandFinish3		BE 18-10-258
230	QC	2 pcs		9/7/18	0.00	0.00	QC3		OCT 09 2018 68
240	Packaging	2 pcs		9/7/18	0.00	0.00	Packaging3-1	OCT 12 2018	DAS 9-89
250	QC21-SA	2 Ea		9/7/18	0.00	0.00	QC21		DR 18/10/12

Part Op 100 - 1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G 2-Debur and Descriptions: bevel ends for welding

120 - 1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8808 AR AL ROD

Batch: M134785 2-Grind Fwd End Cap weld flush

160 - 1-1-Weld 1 End Cap as per QSI 004 & Dwg AR AL ROD Batch: M134785 2-Inspect for foreign object as per QSI 024 3-Grind Fwd End Cap weld flush

210 - START Time: 12:55 OVEN TEMPERATURE: 320° FINISH TIME: 1:25

wing walk. S098120

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	2 Ea (1 ea)	90-Start up Operation	S104007
D2734	Step End Plate	2 Ea (1 ea)	120-Large Fab	S077383
D3040-1	Mounting Lug	4 Ea (2 ea)	120-Large Fab	① S101878 ① S106291 F125837 ②
D3040-3	Mounting Lug	4 Ea (2 ea)	120-Large Fab	128957
D2734	Step End Plate	2 Ea (1 ea)	160-Large Fab	S077383

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	2	3	0
120-Large Fab	D2734	2	34	0
	D3040-1	4	2	0
	D3040-3	4	18	0
160-Large Fab	D2734	2	34	0
Part Specifications				
Specifications could not be found.				

Plex 8/9/18 7:59 AM Dart.lajeunesse.marie



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Container No: S113156



Part: D3043-042

Job No: 181786

Serial No/Batch: S113156

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/24/18

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	

Date : 18/9/27	Sequence #:	QTY Affected :	MRB (QSI042) 12 18/9/27
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Description Work Order Deviation	Disposition	
Drill vent holes as required to ensure proper welding. Ø0.125 holes, CSK Ø0.225 x 100; 20" from end on bottom of step. Plug with MS20601AD4WZ before paint.	Acceptable. See DZ946 Rev. C for reference.	Completed By 18-9-28 Lead hand / Supervisor QC / QA Coordinator

Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>	☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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